Work Order ID 86560

July-05-12 10:25:45 AM

86560

Item ID:	D3850-1KIV	**Accept**	*N900040100*
Revision ID:		**Setup** Start	*NS1*
Item Name:	Hat Bin-Ivory	Stop	*NS2*
Start Date:	7/05/12	**Start Qty:** 1.00	*1*
Required Date:	7/16/12	**Req'd Qty:** 1.00	*1*
Cust Item ID:			
Customer:			
Reference:			

Run Start *NR1* Stop *NR2*

Approvals: **Process Plan:** V **Date:** ____ **Tooling:** ____ **Date:** ____

QC: ____ **Date:** ____ **SPC (Y/N):** ____ **Date:** ____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

Draw Nbr	Revision Nbr
D3850	Rev C

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100 *100* HandThermo Hand Finishing Thermoforming	Memo 1-Machine set up 2- Cut sheet to required blank size	0.00 0.00				x1			Dh 12/08/14
105 *105* HandThermo Hand Finishing Thermoforming	Dry Material Memo Dry Sheet as per QSI022 KYDEX Temp: 150°F Time IN: 7:00 pm 12/08/13 Time OUT: 7:00 am 12/08/14	0.00 0.00				x1			Dh 12/08/14

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Item ID: D3850-1KIV
Revision ID:
Item Name: Hat Bin-Ivory

Accept *N900040100*

Setup **Start** *NS1*
Stop *NS2*

Start Date: 7/05/12 **Start Qty:** 1.00 *1*
Required Date: 7/16/12 **Req'd Qty:** 1.00 *1*
Reference:

Cust Item ID:
Customer:

Run **Start** *NR1*
Stop *NR2*

Approvals: **Process Plan:** ____________ **Date:** ________ **Tooling:** ________ **Date:** ________
QC: ____________ **Date:** ________ **SPC (Y/N):** ________ **Date:** ________

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 *110* Thermoform Thermoforming Machine	 Memo Thermoform as per Dwg. D3850 and folio FTA036 using tool DT 9338 Dwg. Rev. C Folio Rev. B	0.00 0.00				x1			Dh 12/08/14
120 *120* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00				x1			Dh 12/08/14.
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				x1			JB 12/08/15

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Item ID: D3850-1KIV
Revision ID:
Item Name: Hat Bin-Ivory

Accept *N900040100*

Setup Start *NS1*
Stop *NS2*

Start Date: 7/05/12 **Start Qty:** 1.00 *1*
Required Date: 7/16/12 **Req'd Qty:** 1.00 *1*
Reference:

Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** ________ **Date:** ________ **Tooling:** ________ **Date:** ________
QC: ________ **Date:** ________ **SPC (Y/N):** ________ **Date:** ________

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* HandThermo Hand Finishing Thermoforming	**Memo** 1) Trim to Finished Dimensions	0.00 0.00				x 1			DAS 07 9-89 12/08/15
150 *150* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB **Memo**	0.00 0.00				x 1			DAS 07 9-89 12/08/15
160 *160* QC Quality Control	QC5- Inspect part completeness to step on W/O **Memo**	0.00 0.00 SMB 12-8-16	DAS 16 9-89 12/08/16			1			

Work Order ID 86560 *86560*

July-05-12 10:25:45 AM

Item ID: D3850-1KIV **Accept** *N900040100* **Setup Start** *NS1*

Revision ID:

Item Name: Hat Bin-Ivory **Stop** *NS2*

Start Date: 7/05/12 **Start Qty:** 1.00 *1* **Cust Item ID:**

Required Date: 7/16/12 **Req'd Qty:** 1.00 *1* **Customer:**

Reference:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** ________ **Date:** ________ **Tooling:** ________ **Date:** ________

QC: ________ **Date:** ________ **SPC (Y/N):** ________ **Date:** ________

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 *170* Packaging Packaging	Identify as per dwg & Stock Location:_______ Memo	0.00 0.00	Sf			1x		SL	12/8/23
180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00				MLJ			12/08/24

MF 12-08-23

Picklist Print

July-05-12 10:25:44 AM

Work Order ID: 86560

Parent Item: D3850-1KIV

Parent Item Name: Hat Bin-Ivory

Start Date: 7/05/12 **Required Date:** 7/16/12

Start Qty: 1.00 **Required Qty:** 1.00

Comments: IPP RevA: New issue DD verified by:EC Material 10/04/21 DL IPP Rev B Add Step 105 Dry

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MKYD6185S.125-P3-62015 6185 KYDEX .125"		Purchased	No			110	sf	838.6293	**11.41**	**12.010526**			DAS 07 9-89

Location	Loc Qty	Loc Code
therm	838.62929	
110426	838.62929	

12.01 sq ft.

12/08/15.

DART AEROSPACE LTD	Work Order:	86560
Description: Hat Bin	Part Number:	D3850-1KIV/KGY
Inspection Dwg: D3850 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than N/A "				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

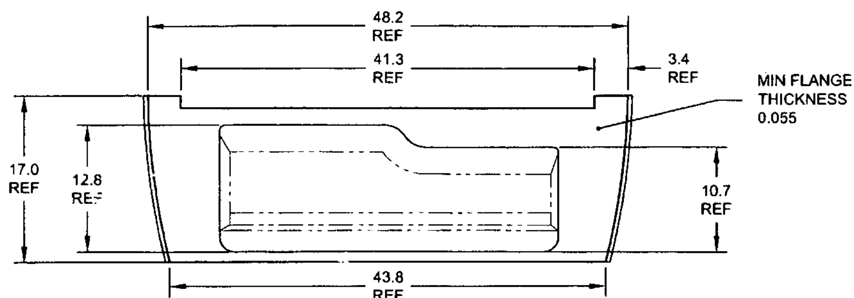
Measured by:	Dh.	Date:	12/08/14

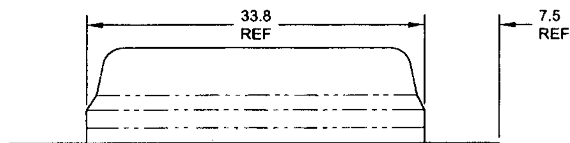
TRIMMING SECTION

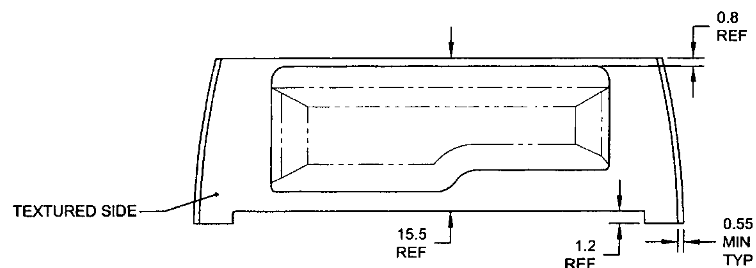
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.55	Min	0.589"	✓		Vernier DL-02	
0.055	Min	0.100"	✓		CAL-THEAT	
0.030	Min	0.035"	✓		ULTRA	

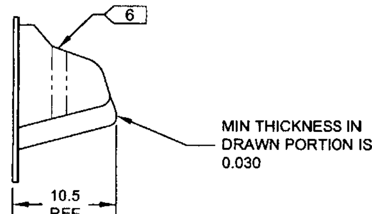
Measured by:	Dh.	Date:	12/08/15
Audited by:	DAS 16 12/08/14	Date:	
Prototype Approval:	N/A	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.06.26	New Issue	KJ	









al 0 865610

RELEASED 09/05/22

D3850-1 HAT BIN
(BELL 206 L3/L4)

REV.	DESCRIPTION	BY	DATE
C	ADD STEEL GRAY COLOUR OPTION, ADD IVORY P/N D3850-1KIV AND ADD STEEL GRAY P/N D3850-1KGY (ZN A5-1)	PH	09.05.05
B	0.125 THICK WAS 0.080 (ZN A7-1) REASON: TO IMPROVE DURABILITY	PH	09.02.19
A	NEW ISSUE	PH	08.10.20

NOTES:
1) MATERIAL: SEE TABLE
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
7) WEIGHT: 4.5 lbs
8) TOOLING: THERMOFORM PER MOLD DT9338 PER DART QSI 022. TRIM PER MOLD

	PART NUMBER	DESCRIPTION
C	D3850-1KIV	KYDEX 6185, 0.125 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.125-P3-62015)
C	D3850-1KGY	KYDEX 6185, 0.125 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.125-P3-52068)

DESIGN	
DRAWN	
CHECKED	
MFG. APPR.	
APPROVED	
DE APPR.	
DATE	09.05.05

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3850 — REV. C — SHEET 1 OF 1
TITLE: HAT BIN (BELL 206 L3/L4) — SCALE: NTS